

Date: Thursday, 5/4/2006 10:46:24 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 26973					
Estimate Number	: 10531					
P.O. Number	: N/A			Part Number	: D2572	
This Issue	: 5/4/2006		S.O. No. : N/A	Drawing Number	: D2572 REV E	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A		Type : MACHINED PARTS	Drawing Revision	: E	
Previous Run	: 26512		Material	: N/A		
Written By	: See Comment Below			Due Date	: 5/25/2006	
Checked & Approved By	: DJ 06.05.04			Qty:	12	Um: Each
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	7075-T7351 8.25X5.0X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: 26973	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. 26973 Double check by: SG	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/05/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 10:46:25 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 26973

Part Number: D2572

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.6 Step 06/05/16 12

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

MS 06/05/17 12

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06-05-17 13

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-05-18 12

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AL 06/05/18 12

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST479

AL 06/05/18 12

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AL 06/05/18 12

Job Completion



U 06/05/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26973
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.745	1.746	1.746	1.748		
C	3.495	3.505		3.496	3.498	3.497	3.495		
D	1.745	1.755		1.745	1.746	1.746	1.748		
E	7.990	8.010		7.997	8.000	8.004	8.004		
F	0.490	0.510		0.499	0.499	0.496	0.500		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.491	0.490	0.492	0.498		
J	1.174	1.184		1.177	1.177	1.175	1.178		
K	0.558	0.578		0.564	0.564	0.564	0.563		
L	1.174	1.184		1.177	1.177	1.175	1.178		
M	1.490	1.500		1.492	1.494	1.493	1.497		
N	2.495	2.505		2.490	2.496	2.495	2.496		
O	3.869	3.879		3.872	3.871	3.872	3.872		
P	0.115	0.135		0.123	0.122	0.123	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.248	0.247	0.249	0.249		
S	0.115	0.135		0.127	0.122	0.124	0.123		
T	0.178	0.198		0.183	0.183	0.183	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.242	0.247	0.242	0.240		
W	0.115	0.135		0.127	0.125	0.120	0.127		
X	0.307	0.312		0.311	0.311	0.311	0.309		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.362	0.366	0.361		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.620	0.623	0.620		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.246	0.242	0.243		
AE	1.375	1.395		1.379	1.382	1.379	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.253	0.250	0.251	0.247		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	0.030	0.030	0.030		

Accept/Reject

Measured by:	<i>EP</i>	Audited by:	<i>MR</i>
Date:	06/05/14	Date:	06/05/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	26973
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
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B	1.745	1.755		1.745	1.746	1.748	1.746		
C	3.495	3.505		3.497	3.498	3.497	3.497		
D	1.745	1.755		1.745	1.746	1.748	1.746		
E	7.990	8.010		8.004	8.004	8.003	8.003		
F	0.490	0.510		0.494	0.497	0.498	0.493		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.495	0.501	0.495	0.498		
J	1.174	1.184		1.177	1.176	1.175	1.175		
K	0.558	0.578		0.565	0.566	0.566	0.565		
L	1.174	1.184		1.177	1.176	1.175	1.175		
M	1.490	1.500		1.496	1.492	1.495	1.493		
N	2.495	2.505		2.497	2.496	2.497	2.497		
O	3.869	3.879		3.874	3.872	3.870	3.872		
P	0.115	0.135		0.126	0.123	0.124	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.249	0.249	0.251		
S	0.115	0.135		0.124	0.122	0.122	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.242	0.239	0.236		
W	0.115	0.135		0.117	0.119	0.120	0.117		
X	0.307	0.312		0.310	0.310	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.361	0.365	0.368	0.370		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.622	0.620	0.621		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.241	0.242	0.244	0.246		
AE	1.375	1.395		1.388	1.384	1.387	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.246	0.247	0.248	0.246		
AI	2.000	2.020		n/a	n/a	n/a	n/a		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	ED	Audited by:	M8
Date:	06/05/15	Date:	06/05/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SPM

DART AEROSPACE LTD				Work Order: 26973	
Description: Saddle, Fwd Inboard				Part Number: D2572	
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

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B	1.745	1.755		1.745	1.748	1.748	1.748		
C	3.495	3.505		3.496	3.499	3.499	3.501		
D	1.745	1.755		1.745	1.748	1.748	1.748		
E	7.990	8.010		8.003	8.003	8.002	8.003		
F	0.490	0.510		0.491	0.500	0.500	0.498		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	0.499	0.498	0.497		
J	1.174	1.184		1.175	1.180	1.180	1.180		
K	0.558	0.578		0.566	0.568	0.568	0.567		
L	1.174	1.184		1.179	1.180	1.180	1.180		
M	1.490	1.500		1.493	1.497	1.497	1.497		
N	2.495	2.505		2.495	2.500	2.501	2.501		
O	3.869	3.879		3.873	3.873	3.872	3.871		
P	0.115	0.135		0.124	0.120	0.121	0.120		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.246	0.245	0.244		
S	0.115	0.135		0.122	0.123	0.124	0.126		
T	0.178	0.198		0.188	0.189	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.966	2.960		
V	0.230	0.250		0.239	0.244	0.244	0.244		
W	0.115	0.135		0.117	0.124	0.125	0.124		
X	0.307	0.312		0.310	0.310	0.311	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.359	0.360	0.361	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.622	0.622	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.066		
AD	0.240	0.260		0.243	0.244	0.241	0.244		
AE	1.375	1.395		1.388	1.386	1.386	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.257	0.251	0.250	0.252		
AI	2.000	2.020		W14	W13	W14	W14		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		

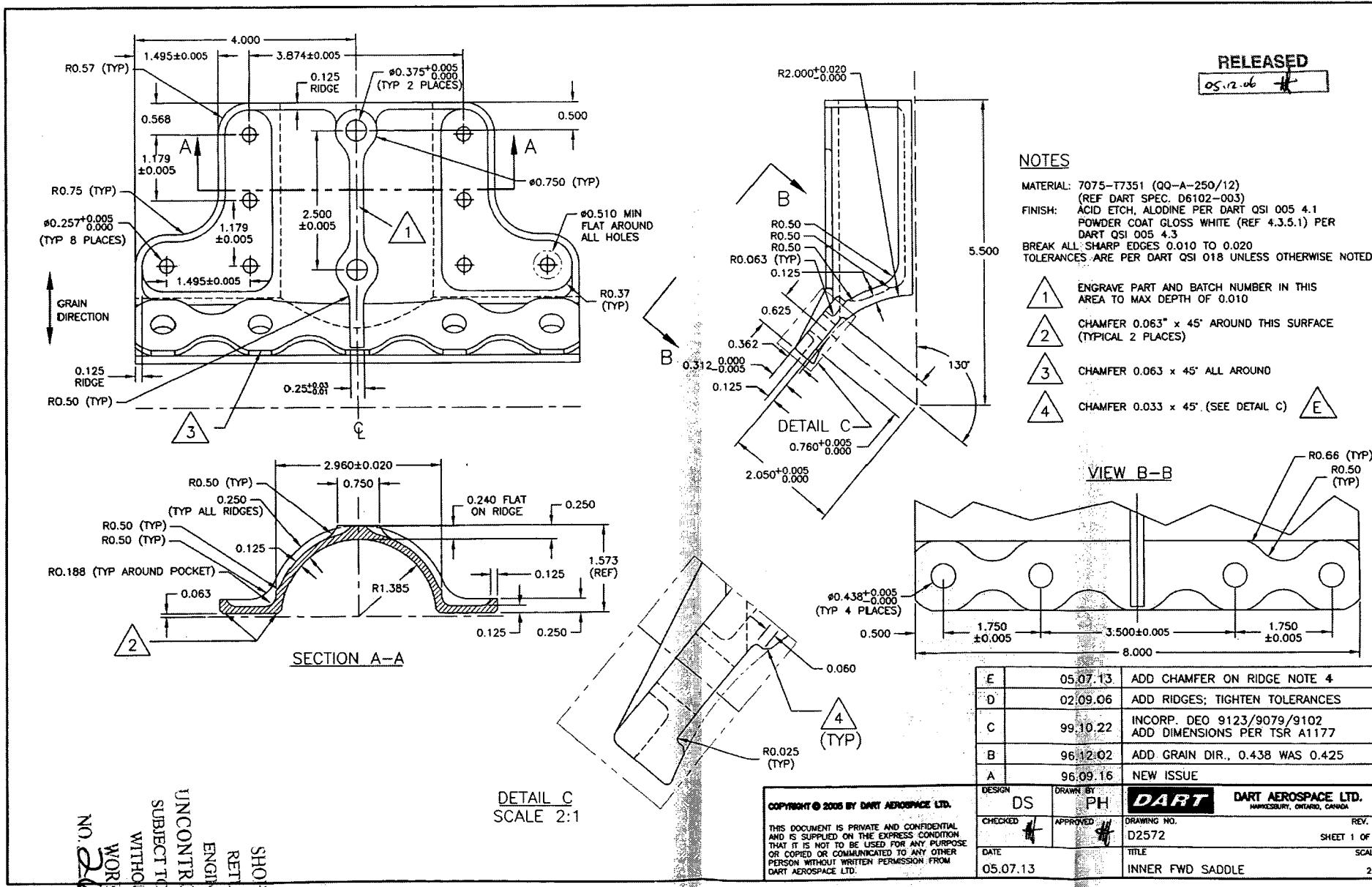
Accept/Reject

Measured by:	EP / J.G.	Audited by:	MB
Date:	06/05/16	Date:	06/05/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JL

RELEASED

05.12.06



WORK ORDER
NO. 26973
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

